	PM		*1129	993*							Page 1
)-1 rcement Plate	D34	50-1 12993	Accept	*N900	040	100)* s	_		171	S1* S2*
014 Start Q	Otv: 16.00	*16*			D:						
a recqu	Qiji 10.00	^1h^		Customer:							
ess Plan:	MF.	Date: 14-2-11	Tooling:	Da	ate:		F			~1/1	R1*
		Date:	_ SPC (Y/N): _	Da	ate:				Stop	*N	R2*
			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept. Qty	Reje Qty			Insp. Stamp
Revision Nb	r					-		•			
Rev A											
FLOW W	ATER JET		0.00				11			****	7 44 -0
			0.00 Prog Rev: A	_ 2-			_16_		<u> </u>		<u>Jm14-</u> 02-1
QC2- Ins _j	pect parts off m	achine FAI/FAIB	0.00								
	Memo	!	0.00				16		<u> </u>		Jm14-02-1
QC8- Ins	pect parts - seco	ond check	0.00 DAS 27 9-39 0.00 1	B			16				
	Operation Notes Revision Notes A FLOW W	Operation Description Revision Nbr Rev A PLOW WATER JET Memo 1-Cut as per Deburr if ne QC2- Inspect parts off m Memo QC8- Inspect parts - second	2014 1:24:33 PM O-1 O-1 O-1 O-1 O-1 O-1 O-1 O-	2014 1:24:33 PM O-1 rement Plate 1014 Start Qty: 16.00 *16* 1014 Req'd Qty: 16.00 *16* Date:	Accept	Accept	Accept	Accept *N900040100* **N900040100* **N900040100* **N900040100* **N900040100* **N900040100* **N900040100* **Cust Item ID: Customer: **Date: Date: Date: Date: SPC (Y/N): Date: Operation Description Revision Nbr Rev A **Out Item ID: Customer: **Date: Date: Date: Dote: SPC (Y/N): Date: Operation Description Revision Nbr Rev A **Out Item ID: Customer: **Date: Date: Dote: Dote: Operation Poscription Revision Nbr Rev A **Out Item ID: Customer: **Date: Dote: Dote: Dote: Operation Poscription Revision Nbr Rev A **Out Item ID: Customer: **Date: Dote: Dote: Operation Description Revision Nbr Rev A Out Item ID: Customer: **Date: Dote: Dote: Operation Double: Out Item ID: Customer: **Date: Dote: Dote: Dote: Double: Double: Double: Double: Double: Double: OC2- Inspect parts off machine FAI/FAIB Out Double: Double: OC3- Inspect parts - second check Out Double: Double:	Accept NOO No No No No No No N	2014 1:24:33 PM Description Revision Nbr Rev A PLOW WATER JET Memo 1-Cut as per Dwg D3450 Dwg Rev: A PLOW WATER JET Memo 1-Cut as per Dwg D3450 Dwg Rev: A Prog Rev: A PLOW WATER JET Memo 1-Cut as per Dwg D3450 Dwg Rev: A Prog Rev: A P	2014 1:24:33 PM 2014 Start Qty: 16:00

												DQA:	Da	te: _	
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												QA Closed:	Da	te:	
Work Orde	· ·					DISPOSITION				AGAINST (DEI	PARTMENT	PROCESS		
Work Orde	' -					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	H	Quality
	_					Use-as-is	1		noforming	Finishing			e/Packaging	П	Other
NCR N	lo					Work Order Update			Large Fab	Composite			Supplier		
Root					1	ption of work order update	1	Initial		ction		Sign &		Ì	
Cause	\perp	Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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	c	racks				Broken/Damaged		Inspecti	on Incomplete	[Part Incorre	ct		Weld
	C	rushed/0	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear		Part Lost/M	ssing		Wrong Stock Pulled
	\Box c	uffs				Contamination		Maintenance				Part Moved		•	•

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Work Order ID 112993 *112993* Page 2 Tuesday, February 11, 2014 1:24:33 PM Item ID: D3450-1 Accept *N900040100* Start Setup **Revision ID:** Stop **Item Name:** Reinforcement Plate *16* **Start Date:** 2/11/2014 **Start Qty:** 16.00 **Cust Item ID:** Required Date: 2/28/2014 Req'd Qty: 16.00 *16* **Customer:** Reference: Start Run Date:_____ **Approvals:** Process Plan: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept Reject Insp. **Work Center ID** Description Qty Qty Number Stamp **Run Hours** Code DAS 130 Identify as per dwg & Stock Location. 0.00 26 *130* Packaging 0.00 Memo Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

OC

Memo

0.00

Quality Control

P14-02-20 ML 14-2-18

											DQA:	Date:	٠ ،
NCR:	Yes	/ No				WORK ORDER NON-C		NFORM	MANCE / UPD				
											QA Closed:	Date:	
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	 No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				`	Descri	ption of work order update	1	nitial	Actio	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										-			
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General					•	-	-
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ľľ	Centre No	t Concer	ntric to	O/S	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	-	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	∐ ⁽	Crushed/0	Crimped.		_	Burrs		Instruct	tions Incomplete/Ur	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
	\bigsqcup^{c}	Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Outside Dimensions

Out of Sequence

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Tuesday, February 11, 2014 1:24:32 PM

Work Order ID:

112993

Parent Item:

D3450-1

Parent Item Name:

Comments:

Reinforcement Plate

KJ/JLM

IPP A05.08.30New issue IPP Rev:B Now Wateriet

06-11-28 JLM

Start Date: 2/11/2014

Required Date: 2/28/2014

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B9 250X06.000 6061-T6 Bar .250 x 6.00		Purchased	No			100	f	112.1100	0.2708	X	259.	FT.	JM14-02-16

Location Loc Qty -MAT051 112.11 121040 0.15 14.56 123279 125386 16.66 3.74 m126647 77 Loc Code

m6061765,250

25024

125024.

											DQA:	Date	à:a_
NCR:	Yes	/ No				WORK ORDER NON-O	COI	VFORI	MANCE / UPI	DATE			
											QA Closed:	Date	2:
Work Ord	or.					DISPOSITION	,			AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	C1.					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update]		Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	<u> </u>	I Initial	Act	tion	Sign &	<u> </u>	
Cause		Date	Step	Qty	1	or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data			<u> </u>				T	<u>_</u>					
Equip/Tooling]											
Operator]											
Material					[1						
Setup													
Other													
Process	L	}											
Supplier													
Training	L												
Unapproved	<u> </u>	L	1								1		
							AUI	T CATE	GORY				
Landi		7			_	General	_	1		_	- 1	_	
	<u> </u>	Bending				Bend		Grain			Ovalized	-	Pressure/Forced
	╙	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa		_	Over/Unde	 	Temperature/Cure
		Cracks				Broken/Damaged		1	ion Incomplete	_	Part Incorre	<u> </u>	Weld
		Crushed/	Crimped.		<u></u>	Burrs	L	4	tions Incomplete/I	Unclear	Part Lost/N	- L	Wrong Stock Pulled
	$ldsymbol{ld}}}}}}$	Cuffs				Contamination	\perp	Mainte	enance		Part Moved		
1	Heat Treat				Countersink	Mislabeled				Positioned	Wrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

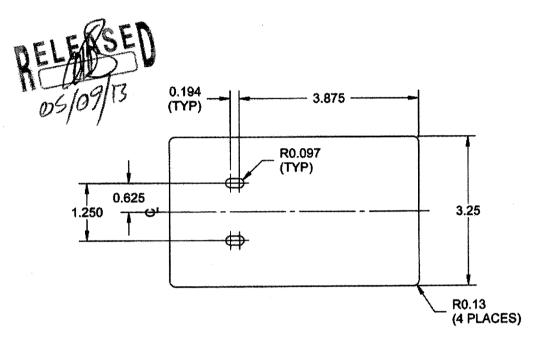
Drawing

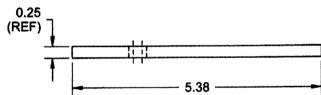
Finish

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1		•
DRAWN E	DWKI WEKOSI WOE I	
	DRAWING NO. D3450	REV. A SHEET 1 OF 1
- W	TITLE	SCALE
05.08.25	BLADE FOLD KIT PLATES	1:2
05.08.25	NEW ISSUE	
	05.08.25	DRAWN BY DART AEROSPACE L HAWKESBURY, ONTARIO, CAN D3450 TITLE BLADE FOLD KIT PLATES





D3450-1 REINFORCEMENT PLATE

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.250)
2) PART IS SYMETRICAL ABOUT CENTER LINE.
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Dat	e:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composi				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								-				
Equip/Tooling												
Operator		1										
Material		1		4								
Setup												
Other												
Process												
Supplier												
Training						1						
Unapproved		<u> </u>										
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Landir	ng Gear			_	General					•	r	
, ,	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Concei	ntric to (o/s	BOM/Route	-	Hardwa			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	-		ion Incomplete		Part Incorre	· · · · · · · · · · · · · · · · · · ·	Weld
	Crushed/	Crimped.			Burrs	-		ions Incomplete/	'Unclear	Part Lost/M	, i	Wrong Stock Pulled
	Cuffs				Contamination	-		enance		Part Moved		
	Heat Trea				Countersink	\vdash	Mislabe			Positioned \		
	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misread	t e		Power Loss/	/Surge	Other
	Ripples ir			<u> </u>	Drill Holes	\vdash	Offset					
	Torque V			י 📙	Drawing			Calibration				
	Turning S	-		L	Finish	-		Sequence		·		
į	M/SVO/TV	list in Tub	20	- 1	Folio	-1 14	Outside	Dimensions				

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DART AEROSPACE LTD	Work Order:	112993
Description: Reinforcement Plate	Part Number:	D3450-1
Inspection Dwg: D3450 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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	·								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
5.38	+/-0.030	5.391° 3.253° 1.254°			U	Some			
3.25	+/-0.030	3,253	_		Ų				
1.250	+/-0.010	1.254"	_		4				
0.194	+/-0.010	0.196° 3.879° 0.253			J				
3.875	+/-0.010	3.879"			✓ ·				
0.250	+/-0.010	0.253	_		ν				
	·								
			-						

Measured by: Jm	Audited by:	27 9-89	Prototype Approval:	N/A
Date: 14-02-16.	Date:	14/2/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.04.25	New Issue	KJ/DD 1.A	
В	08.10.07	0.250 dimension added	KJ/DD	

												DQA:	Date:	
NCR: Yes / No WORK ORDER:NON-CONFORMANCE / UPDATE														
												QA Closed:	Date:	
Vork Order:							DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. NCR No.							Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root Descri					crip	tion of work order update		Initial Action		tion	Sign &	· - · ·		
Cause		Date	Step	Qty	1		·		ief Eng	Description		Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining											·			
FAULT CATEGORY														
Land	ng (1			ı		General		Ī		_	Ovalized		¬
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	M/Route ken/Damaged s tamination ntersink Too Short I Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			tolerance ct issing Vrong 'Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning Sequence					Finish		Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

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